



Dart Aerospace Ltd.
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D4854-3
Job Sheet 170113



Part No: D4854-3

Job Qty: 10 ea

Part Name: Lower Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4854 REV.B IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.07 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Waterjet		ac 18/01/14
100	Waterjet	10 pcs	1/25/18	1/25/18	0.00	2.50	Waterjet1		ac 18/01/14
105	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC2 Waterjet-1		ac 18/01/14
110	Mill Conv	10 pcs	1/25/18	1/25/18	0.00	8.77	Mill Conv 1		J.L.L. 18-01-25
120	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC2 Machining-3		J.L.L. 18-01-25
130	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC8 Machining-3		FK 18-1-29
140	HandFinish	10 pcs	1/25/18	1/25/18	0.00	0.08	HandFinish1		18-01-31 8
150	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC7-4		REB 18-02-01
160	Powdercoat	10 pcs	1/26/18	1/26/18	0.00	0.50	Powdercoat1		BK 18-02-01
170	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC3		11 FEB 01 2018
180	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-2		0889 524 573/9
190	QC21-SA	10 Ea	1/26/18	1/26/18	0.00	0.00	QC21		21 FEB 02 2018

Part Op 100 - CUT AS PER FILE DWG REV: B PROG REV: B DEBURR

Descriptions: 110 - MILL RADS DRILL HOLES AS PER DWG DEBURR OPEN SLOT TO .260" AS PER DWG

160 - ***MASK AS PER DWG*** START TIME: 1:20 OVEN TEMPERATURE: 320 FINISH TIME:

1:50

M 18467

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X04.000	4	32	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S032558

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Lower Bracket

PART NO: D4854 - 3

Original Serial #: S032558

Revision:

Operation:

Change No:

Start up Operation 01/16/18

Job No: 170113

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Scrap ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Use-as-is ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

